

Work Order ID 102074

Thursday, May 23, 2013 12:57:33 PM

102074*Ship today*

Page 1

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Tail Rotor Pedal Lockout Installation

Stop ***NS2***

Start Date: 5/23/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/23/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MLF*Date: *13-5-23*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D119-827

C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D119-827-011 CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Work Order ID 102074

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102074

Page 2

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

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Start Date: 5/23/2013 Start Qty: 1.00

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Cust Item ID:

Required Date: 5/23/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-827-011 Location: _____								
140									
	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1 J 13-5-23MLJ 13-05-23Wmf
13-05-23

Picklist Print

Thursday, May 23, 2013 12:57:33 PM

Page 1

Work Order ID: 102074

Parent Item: D119-827-011

Start Date: 5/23/2013

Required Date: 5/23/2013

Parent Item Name: Tail Rotor Pedal Lockout Installation

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13-01-09 REV B
JLM VERIFIED:DD IPP REV:C 12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4704-041 Expandable Pin Assembly	SM	Manufactured	No			110	Each	0.0000	(1)	B 99776	ML		
D4703-041 Lock Pin Assembly	SM	Manufactured	No			110	Each	6.0000	(2)	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST117		2							
				97372		2							
				ST119		4							
				93671		4							
D4710-1 Spacer	SM	Manufactured	No			110	Each	16.0000	(1)	B 93671	ML		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		3							
				93675		3							
				ST118		1							
				89850		1							
				ST119		12							
				101283		12							
D4721-1 Decal	SM	Manufactured	No			110	Each	12.0000	(1)	B 101283	ML		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST119		12							
				93676		12							

13/05/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 2

Work Order ID: 102074

Parent Item: D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout Installation

Start Date: 5/23/2013

Required Date: 5/23/2013

Start Qty: 1.00

Required Qty: 1.00

AN4-11A
Bolt

Purchased No

110 Each 155.0000

Location

Loc Qty

Loc Code

FG 20
120731 20
ST514 50
123900 50
ST517 85
124221 85

MS141414
Nut

Purchased No

110 Each 62.0000

Location

Loc Qty

Loc Code

ST331 62
123832 7
123900 5
124858 50

MS24665-153
COTTER PIN

Purchased No

110 Each 164.0000

Location

Loc Qty

Loc Code

ST323 164
107139 164

NAS1149D0416J
Washer

Purchased No

110 Each 37.0000

Location

Loc Qty

Loc Code

ST293 37
123741 37

13/05/23.

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print.

Thursday, May 23, 2013 12:57:33 PM

Page 3

Work Order ID: 102074

Parent Item: D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout Installation

Start Date: 5/23/2013

Required Date: 5/23/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J
Washer

Purchased No

110 Each 4,832.0000

8

8

Shp

Location

Loc Qty

Loc Code

FP001

6

122441

6

ST007

12

121912

12

ST294

4814

119097

8

124198

221

124778

4585

124778

M.L.D.

NAS6604D16
Bolt

Purchased No

110 Each 28.0000

2

2

Shp

Location

Loc Qty

Loc Code

ST277

28

123832

8

125574

20

123832

M.L.D.

13/05/23

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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Work Order ID 102074

Thursday, May 23, 2013 12:57:33 PM

102074

Page 1

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lockout Installation

Start Date: 5/23/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/23/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *CMF*Date: *B-5-23* Tooling:Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

IIN-D119-827

C

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D119-827-011 CHG002

MLJ B-05-23

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

67.7 WEIGHT AND BALANCE

The following is the net increase associated with the D119-827-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-827-011	0.52 lb	32.6 in	16.9 lb-in	-13.1 in	-6.8 lb-in
Tail Rotor Pedal Lockout	0.23 kg	0.83 m	0.19 kg-m	-0.33 m	-0.08 kg-m

67.8 PARTS LIST

-011	Part Number	Description
X	D119-827-011	TAIL ROTOR PEDAL LOCKOUT
2	D4703-041	LOCKOUT-PIN ASSY
1	D4704-041	EXPANDABLE PIN ASSY
1	D4740-1	SPACER
1	D4721-1	DECAL
2	AN4-11A	BOLT
2	MS14144L4	NUT
2	MS24665-153	COTTER PIN
2	NAS1149D0416J	WASHER
8	NAS1149D0463J	WASHER
2	NAS6604D16	BOLT

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67-00-00

Revision: 0